

Date: Tuesday, 24/02/2009 9:20:03 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SLEEVE
 Job Number : 46051
 Estimate Number : 13173
 P.O. Number :
 This Issue : 24/02/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : 24/02/2009 Type : MACHINED PARTS
 Previous Run : 44825
 Part Number : D36891
 Drawing Number : D3689 REV B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 03/03/2009 Qty: 20 Um: Each
 Written By : *JLM 08.02.24*
 Checked & Approved By :
 Comment : Est Rev:A New Issue 08-02-11 JLM Verified By:EC
 Est Rev:B Material Change 09-01-07 JLM Verified By:EC
 Est Rev:C Add note on material cutting JLM Verified By:JM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M174PHH900R1375 17-4PH SS ROUND BAR 1.375 COND.900



Comment: Qty: 0.4200 f(s)/Unit Total: 84.4200 f(s)
 17-4PH SS ROUND BAR 1.375 ****CONDITION H-900****
 DO NOT CUT MAT ON CHOP SAW, USE BAND SAW ONLY*

M100540 24 09/02/27

2.0 DOOSAN LATHE DOOSAN LATHE



Comment: Doosan Lathe

1- Turn as per Folio FA722 Rev. *A/A* & Dwg D3689 Rev. *B*
 2-CHECK THREAD WITH GO-NO GO GAUGE DT9450 A & B

PTO

3-Deburr per dwg D3689

09/03/03

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

09/03/03 (A)

4.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
 C'sink .188" holes as per dwg D3689

09/03/07 (19)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3689-1 PAR #: N/A Fault Category: Prod / Machines NCR: Yes No DQA: D Date: 09/03/16
D3689-09/04/09/17/16 D205-770-011
Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 09/03/16

NCR: <u>46051</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/03/03</u>	<u>3P</u>	<u>Thread stripped, chips binded tap.</u> <u>R.C: Process.</u>	<u>[Signature]</u>	<u>Scrap: No replace</u>	<u>[Signature]</u> <u>09/03/03</u>	<u>[Signature]</u> <u>0903-10</u>	<u>[Signature]</u> <u>0903-10</u>	<u>[Signature]</u> <u>0903-10</u>

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLEEVE

Job Number: 46051

Part Number: D36891

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

89 09/03/07

(19)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mk 09/03/11

(19)

7.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O:

8382

LPI Per ASTM 1417 LEVEL 2

Certificate of conformity is required

4.8479524

09/03/11

(19)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

09/03/11

(19)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09.03.12

(19)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9/3/13

19x

SP

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

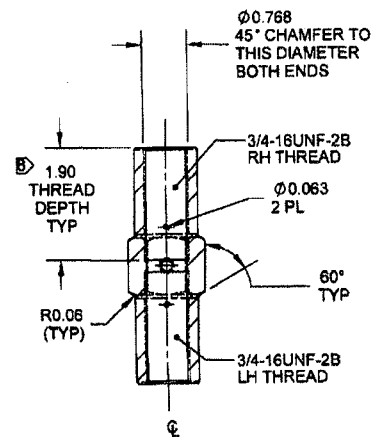
09/03/15

(19)

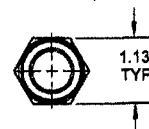
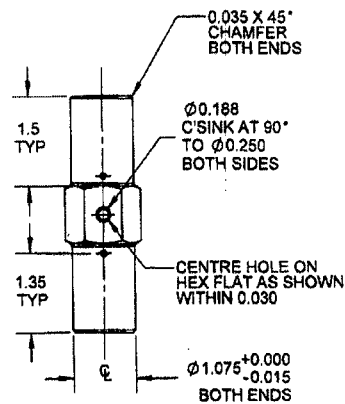
Job Completion



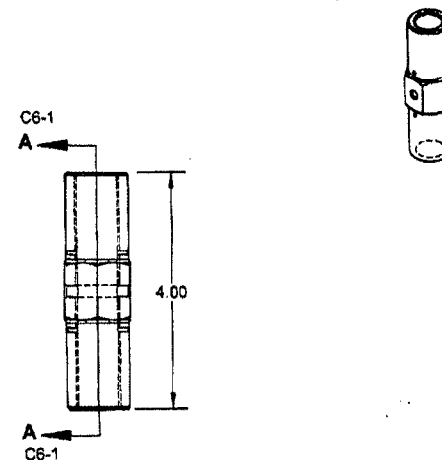
U 09.03.13



SECTION A-A
D3-1



D3689-1 SLEEVE



- NOTES:**
- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.67 lb
 - 8) DIMENSION SHOWN IS MINIMUM DEPTH OF FULL THREAD
 - 9) LPI PER ASTM 1417 LEVEL 2

B	CHANGE TO 17-4PH H-900 (ZN A8-1); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3689	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SLEEVE	NTS
DATE	08.11.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
68/12/15 JMB

W/O 46051



LIQUID PENETRANT TEST REPORT

P- 14935

PAGE 1 OF 1

CLIENT DART AEROSPACE DATE MAR 11-2007 TIME AM ☒ PM ☐
ATTENTION LINDA / CHANTEL ACUREN JOB NO. 188-09-09343
ADDRESS 1270 ABDELDEEN ST PO/WO No. 8392
HAWKESBURY, ON WORK LOCATION HAWKESBURY - SHOP
KOA 1K7 ACCEPTANCE STD. ASTM 1417 REV./DATE 2007
PROJECT F.P.I. ON 100% EXTERNAL
ITEM(S) EXAMINED FIVE CROSS TUBES -
39 MACHINED PARTS - MOTOR MOUNTING

JOB DESCRIPTION WET FLUORESCENT LIQUID PENETRANT INSPECTION PROCEDURE NO. LT-XXXX REV./DATE LT-XXXX-XXX REV./DATE LT-XXXX-XXX
PART NO. — MATERIAL — THICKNESS —
SCOPE ON 39 STAINLESS STEEL PARTS, 5 ALUMINE ALUMINUM X-TUBES

TEST DETAILS
METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND MAGNA FLUX BLACK LIGHT S/N 1165 ☒ OUTPUT > 1000 μ W/CM² ☐ AMBIENT < 2 fc
PENETRANT ZL 67 MINIMUM DWELL TIME 45 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER H2O MINIMUM DRY TIME >10 MIN. OTHER LABINO
DEVELOPER SKD 52 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N — CAL DUE DATE FEB 2008
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE
SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT BLASTED ☐ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/20°F ☐ -4°C/20°F TO 10°C/50°F ☐ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)

9	JOB #	45671
10	#	45670
11	#	46051
11	#	46054
1	JOB #	46094
1	#	46092
1	#	46093
1	#	46371
1	#	46372

ALL ITEMS WERE FOUND ACCEPTABLE

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE Ian Titley DTR # E-19816
TECHNICIAN (SIGNATURE): Mike Littlejohn REPORT REVIEWED BY:
NAME (PRINT): Mike Littlejohn NAME INITIALS
CGSB LEVEL 1st SNT LEVEL — CGSB LEVEL — SNT LEVEL —
CGSB REG. NO. — CGSB REG. NO. —